

Date: Monday, 11/08/2008 10:20:24 AM  
 User: Linda Lacelle

## Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 41083  
 Estimate Number : 12811  
 P.O. Number :  
 This Issue : 11/08/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 11/08/2008 Type : SMALL /MED FAB  
 Previous Run : 35331

Drawing Name : BRACKET

Part Number : D35921  
 Drawing Number : D3592 REV.B  
 Project Number : N/A  
 Drawing Revision : B  
 Material :  
 Due Date : 25/08/2008

Qty: 40 Um: Each

Written By :  
 Checked & Approved By : JUD 08.8-11  
 Comment : Est Rev:A New Issue 07-03.26 ec

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.1460 sf(s)/Unit Total : 5.8380 sf(s)  
 6061-T6 .125 Sheet  
 Batch: 108659 AB 8-8-13

\*\*\*Grain must be Along 4.63\*\*\*\*\*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3592  
 Dwg Rev: B  
 Prog Rev: B AB 8-8-13

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



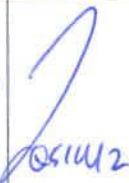


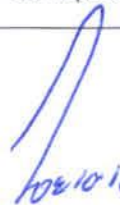
Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Form as per Dwg D3592 using DT8949

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3592-1 PAR #: NA Fault Category: Prod / Process <sup>MASS 25011</sup> NCR: Yes No DQA: Yes Date: 08/10/16  
 QA: N/C Closed: Yes Date: 08/10/16

NCR: 41083		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/10/16	4.0	Parts with the grain direction along the 3.857" length are cracking during welding. R.C: Parts pull during welding along the grain > Process.	 OSIU12	Scrap parts in accordance with CAR 08-026, to try with the grain on a 45°	SB 08/10/16	 08/10/16	 OSIU12	 10/10/16

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 41083

Part Number: D35921

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*SCAP*  
*AS Per*  
*DAR*

*MF*  
*08-10-15*

*08/10*



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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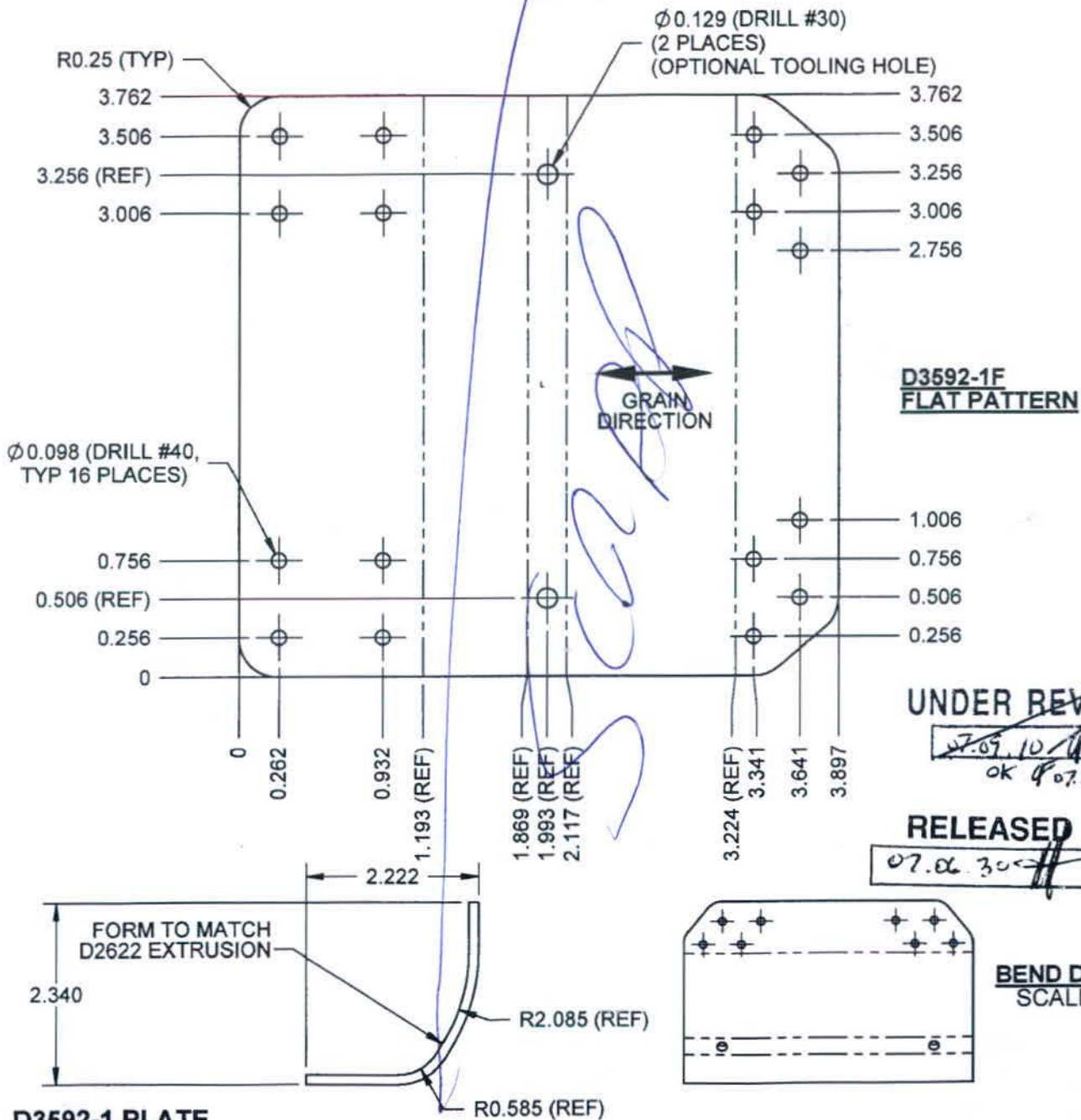
**NOTE:** Date & initial all entries







DESIGN QP	DRAWN BY JC	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED QP	APPROVED [Signature]	DRAWING NO. D3592	REV. B SHEET 1 OF 1
DATE 07.05.31		TITLE PLATE	SCALE 1:1
A	07.01.15	NEW ISSUE	
B	07.05.31	TOOLING HOLES ADDED	



### D3592-1 PLATE

#### NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.125)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

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